

Date:  
User:Thursday, 15/01/2009 11:13:49 AM  
Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 44795  
 Estimate Number : 10721  
 P.O. Number :  
 This Issue : 15/01/2009 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : SMALL /MED FAB  
 Previous Run : 41766  
 Written By :  
 Checked & Approved By : JUD 09.01.15  
 Comment : EST REV> A 05.11.18 new issue EC  
 Est Rev:B Added Step 7 08-11-04 JLM Verified By:EC

Drawing Name : STEP WELDMENT  
 Part Number : D34637  
 Drawing Number : D3463 REV.B  
 Project Number : N/A  
 Drawing Revision : B  
 Material :  
 Due Date : 27/02/2009 Qty: 3 Um: EACH

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304TR0750W120

304 ss round tube .750 x .120w



Comment: Qty.: 1.0000 f(s)/Unit Total: 12.0000 f(s)  
 AISI 304 SS seamless tubing 0.750 OD X 0.120 wall  
 (M304TR0750W120)  
 Batch: M109162 (7X)

M-L 09/01/29 (12)  
M110672 (5X)

2.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
 1-Cut to 13.875"

M-L 09/01/29 (12X)

2-Deburr

M-L 09/01/30 (12X)

3-Bend end as per dwg D3463

FF 09/01/30

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/06 (12)

4.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE  
 1-Mill as per dwg D3463

2-Drill hole &amp; ream to 0.4385" as per dwg D3463

88 09/02/05

3-Deburr

(11)





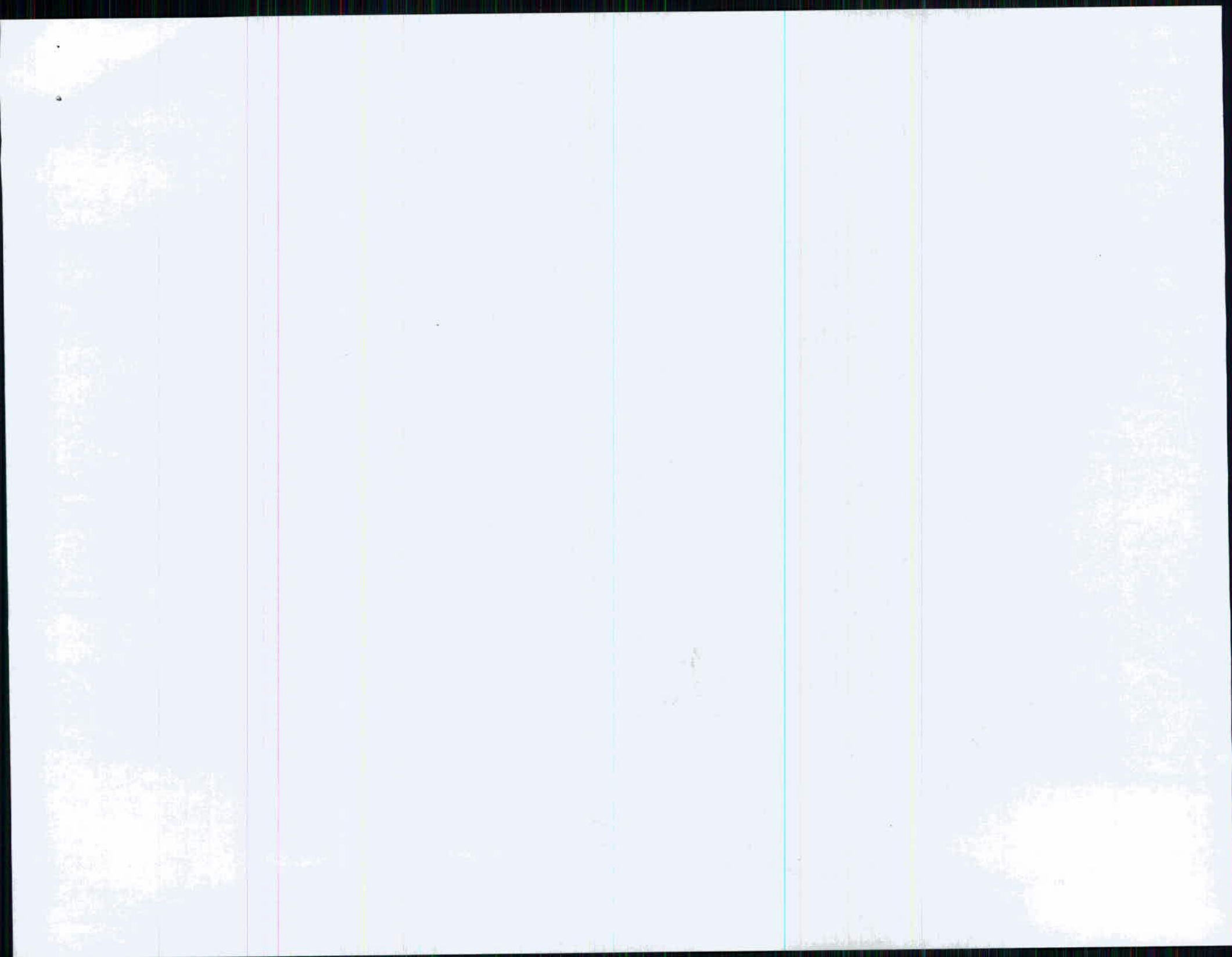
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3463-7 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 2 Date: 09/02/11  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>44795-1</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/02/06</u>	<u>4.0</u>	<u>One part the hole of .437 was off center.</u> <u>R.C. We tried to center the hole with the tube and the tube was cracked.</u>	<u>[Signature]</u>	<u>Scrap &amp; no replace.</u> <u>Centering measurement will be taken on the flat section. Product done manually</u>	<u>SS</u> <u>09/02/06</u>	<u>[Signature]</u> <u>09-02-06</u>	<u>[Signature]</u> <u>09-02-06</u>	<u>[Signature]</u> <u>09-02-06</u>

NOTE: Date & initial all entries





## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 44795

Part Number: D34637

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

28 09/04/09

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JF 09/02/09

7.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1  
Grind .450" rad

M-L 09/02/09

(3K)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/08/09 (43)

9.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: misc

P 09.02.09

(X3)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/10

Job Completion

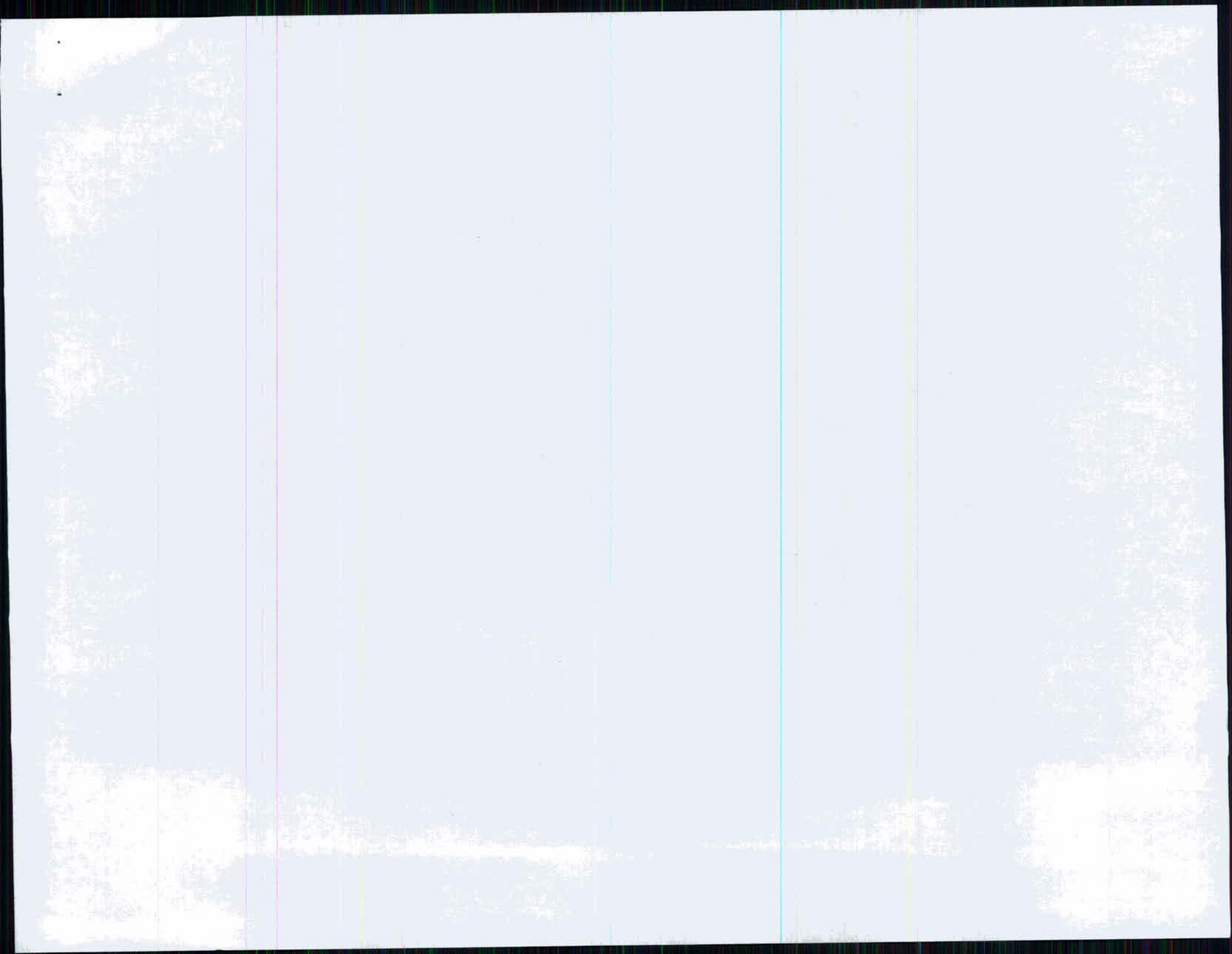


MF 09-02-09









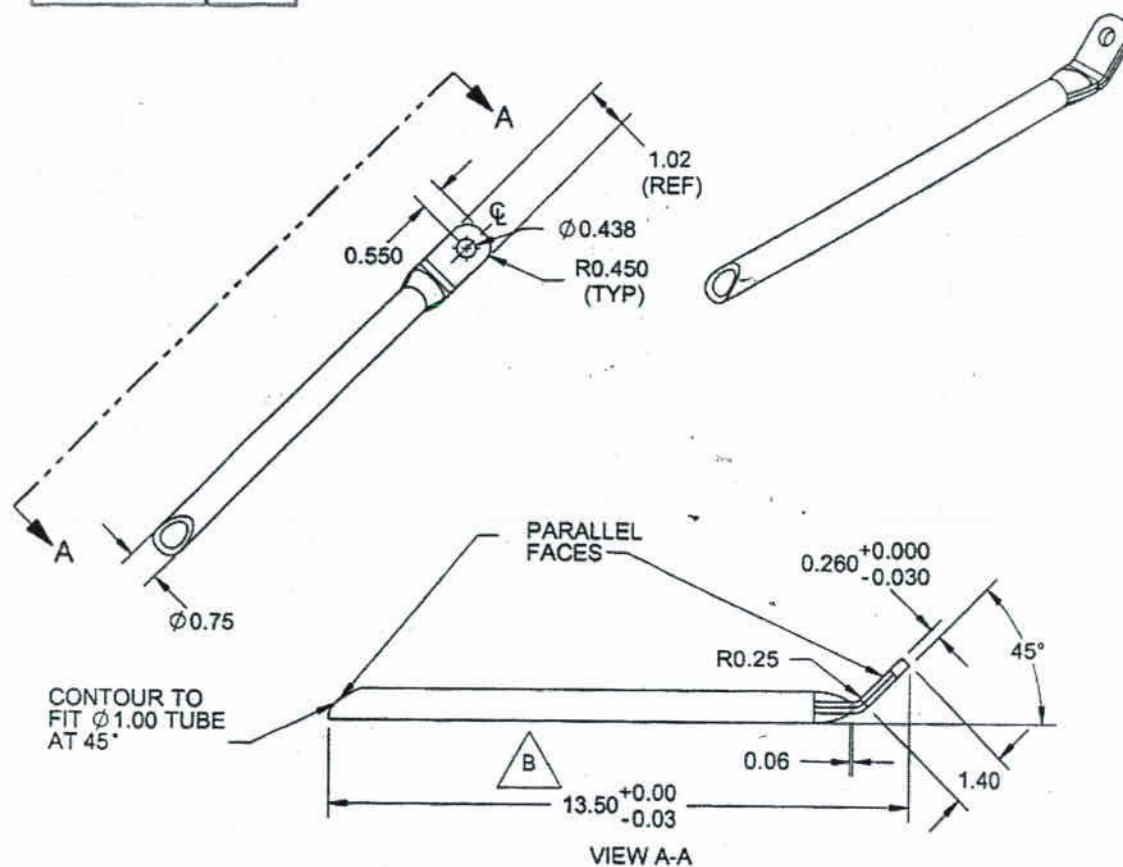


**DART**

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 3 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:4

**RELEASED**

05.12.05 #

**D3463-7 DRAG ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W 120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

SHOP COPY  
RETURN TO:  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 44795

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